

Work Order ID 98216

98216

Page 2

March-08-13 2:48:34 PM

Item ID: D3934-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Clip Assembly
 Start Date: 3/08/13 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 3/11/13 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120						(20)	13-03-13		DAS 09 2-89
QC	Memo	0.00							
Quality Control									
130		0.00							
130						20			13/03/14
Brake NC	Memo	0.00							20 13/03/12
Brake NC	1- C'sink holes as per dwg								
	2- Bend as per dwg D3934								
140	QC5- Inspect part completeness to step on W/O	0.00							
140						(20)	13-03-14		DAS 09 2-89
QC	Memo	0.00							
Quality Control									

141 Install nut plate as per dwg

142 QC 5 (20) 13-03-14 DAS
 09
 2-89

20x

13/03/14

Work Order ID 98216

March-08-13 2:48:34 PM

98216

Page 3

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: ST 073	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

20x **SP**
13-3-14
13/3/18
HB-03-15

Picklist Print

March-08-13 2:48:33 PM

Page 1

Work Order ID: 98216

Parent Item: D3934-041

Parent Item Name: Clip Assembly

Start Date: 3/08/13

Required Date: 3/11/13

Start Qty: 20.00

Required Qty: 20.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 304/316 .040 Sheet		Purchased	No			150	sf	287.5001	0.021	0.4421053		13.03.10	

Location	Loc Qty	Loc Code
MAT020	287.500065	
121380	0.000065	
122732	32	
122753	98.8	
124029	156.7	

MS21075L3
Nutplate

Purchased No

150 Each 404.0000 1 20

Location	Loc Qty	Loc Code
GA	384	
124670	384	
ST318	20	
123832	5	
124551	15	

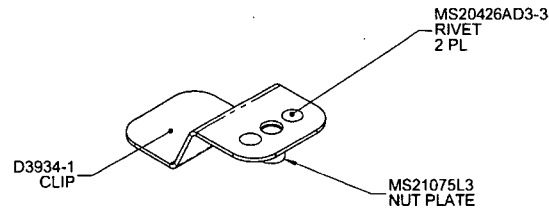
MS20426AD3-3
Rivet

Purchased No

100 Each 7,041.0000 2 40

Location	Loc Qty	Loc Code
GA	65	
122814	65	
ST316	699	
119109	282	
19099	417	
ST333	6277	
121011	69	
123352	6208	

ITEM	QTY .041	P/N	DESCRIPTION
1	X	D3934-041	CLIP ASSEMBLY
10	1	D3934-1	CLIP
20	1	MS21075L3	NUT PLATE
21	2	MS20426AD3-3	RIVET



D3934-041 CLIP ASSEMBLY

W/O 98216

RELEASED
09/05/16

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3934-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.02 lbs

A	NEW ISSUE	PH	09.04.16
REV	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3934	SHEET 1 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	CLIP ASSEMBLY	NTS
DATE	09.04.16	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. WHO IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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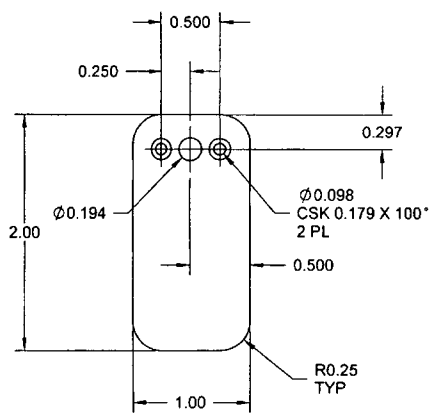
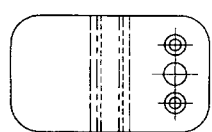
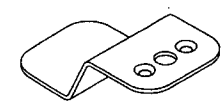
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B

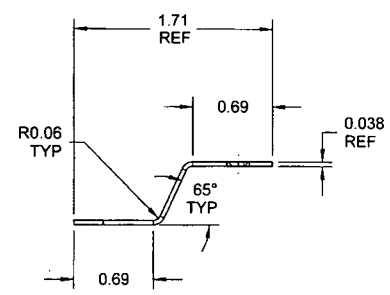
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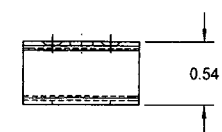
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D3934-1F FLAT PATTERN (1)



D3934-1 CLIP
(MAKE FROM D3934-1F)



NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
20 GAUGE (0.038 THICK)
REF DART SPEC M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

DESIGN	PAJ	DART AEROSPACE LTD	
DRAWN	PAJ	HAWKESBURY, ONTARIO, CANADA	
CHECKED	TE	DRAWING NO.	REV. A
MFG. APPR.	TE	D3934	SHEET 2 OF 2
APPROVED	PAJ	TITLE	SCALE
DE APPR.	PAJ	CLIP ASSEMBLY	NTS
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RELEASED
09/25/25 MP

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